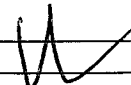



13/04

Date: Friday, 06/04/2007 3:28:45 PM
User: Linda Lacelle

Process Sheet









Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	COLLECTIVE LOCK
Job Number :	31666		
Estimate Number :	11948		
P.O. Number :	N/A	Part Number :	D3372041
This Issue :	06/04/2007	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3372 REV B
First Issue :	N/A	Project Number :	N/A
Previous Run :	26195	Drawing Revision :	B
	Type :	Material :	N/A
	SMALL /MED FAB	Due Date :	12/04/2007
Written By :			
Checked & Approved By :			
Comment :	Est Rev:A Removed from 9 Digit 06-01-13 JLM Est Rev:B Added Key ID 06.03.21 EC		

Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D27287	Decal
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2728-7 Decal B22554		
2.0	D33721	Main Body
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3372-1 Main Body B22281		
3.0	D33725	Cam Lock Shaft
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3372-5 Cam Lock Shaft B22290 B22290		
4.0	D33727	Slider Body
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3372-7 Slider Body B22291		

SB 07/04/10 (2)

Date: Friday, 06/04/2007 3:28:46 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE LOCK

Job Number: 31666

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33731

Cam Lock



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description

1 D3373-1 Cam Lock

CB 23643 C 420A
Keys alike keys disalike
B 32715 B

6.0

AN542A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN5-42A Bolt 16 762

7.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 5/16WC SS Flat Washer M103168

A/RNA/Locktite 262 M102855

8.0

D33841

Cyclic Sock



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3384-1 Cyclic Sock B 26372

9.0

CBL460

Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

X 2 CBL-460 Loop Sleeve ~~M119439~~
M119476

SP 07/04/10 (2)

Date: Friday, 06/04/2007 3:28:46 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE LOCK

Job Number: 31666

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

CBL1240

Cable



Comment: Qty.: 0.6999 f(s)/Unit Total: 1.3999 f(s)

Pick:

Qty Part Number Description Batch

8" CBL-1240 Cable M102439

11.0

AN960416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960-416 Washer M102829
MSS19

12.0

HX81

1/4"-20 SHCS 3/8" long



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HX-81 1/4"-20 SHCS 3/8" long M16471

SAD 07/04/09 (2)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372

Identify as D3372-3

SAD 07/04/09 (2)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 07/04/09 (2)

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as D3369-5

SAD 07/04/09 (2)

Date: Friday, 06/04/2007 3:28:46 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE LOCK

Job Number: 31666

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Tack weld lock shaft as per Dwg D3372

Qty Part Number Description Batch

A/R/N/A SS Rod

M102756

PD 07-04-10 (2)

17.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads

Qty Part Number Description Batch

A/R N/A

Locktite 262

M102855

SAD

07/04/07

(2)

Identify as D3372-053

2-Assemble D3372-051 as per Dwg D3372. Identify as D3372-051 and attach keys Ensure that assembly locks and unlocks smoothly.

SB 07/04/10 (2)

3-Assemble lanyard to cyclic sock as per Dwg D3384

4-Assemble D3384-043 to D3372-051 using 1/4"-20 socket head cap screw and washers as per Dwg D3371.

SB 07/04/10 (2)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/04/10 (2)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C-7/4/10 (2)

Record Keys alike #

Record Keys dislike #

C420A
C420A

Date: Friday, 06/04/2007 3:28:46 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE LOCK

Job Number: 31666

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

②
F 07/04/11

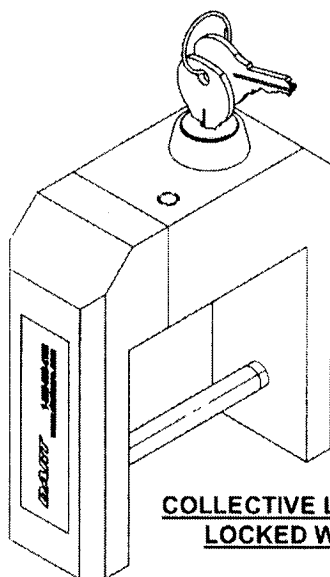
Job Completion



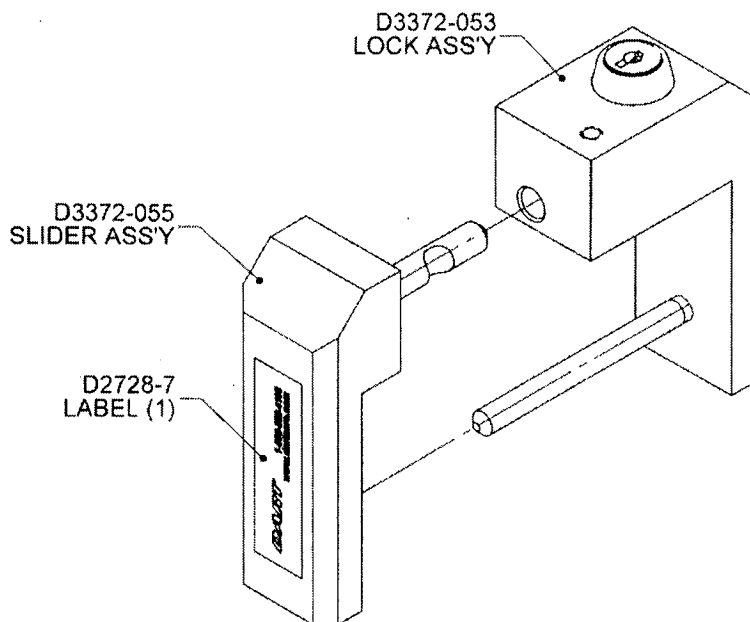
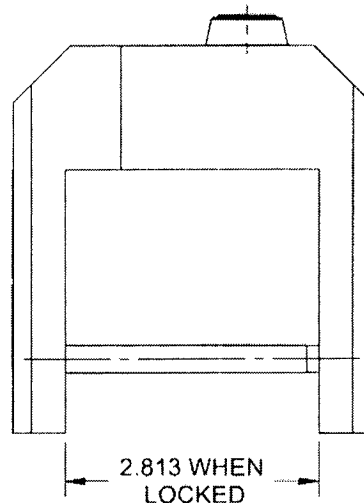
U 07-04-10



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CHECKED	APPROVED	DRAWING NO. D3372	REV. B SHEET 1 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



**COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS**



RELEASED
05/09/28

D3372-051 AS350 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

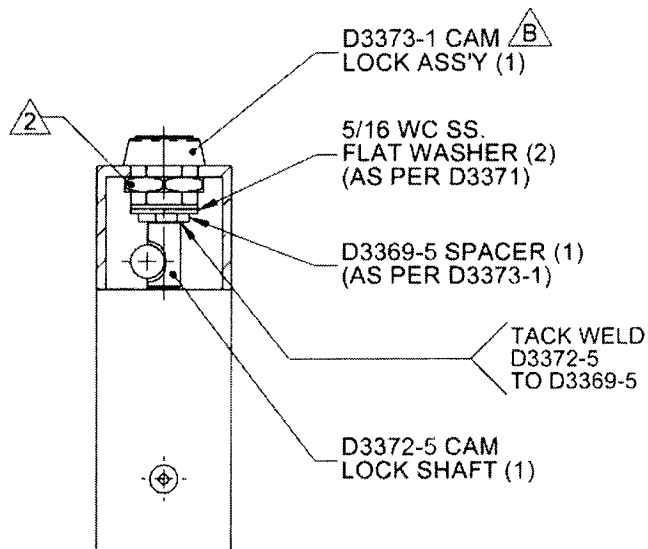
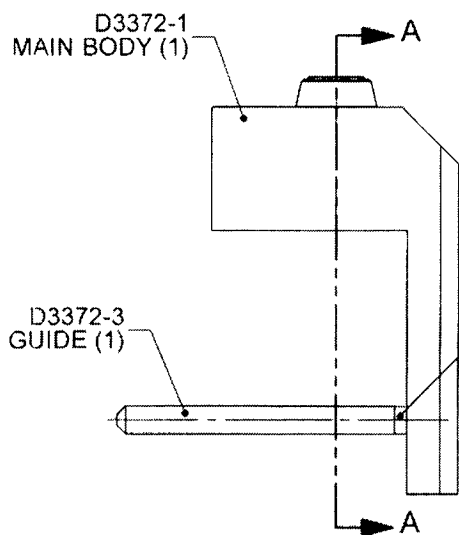
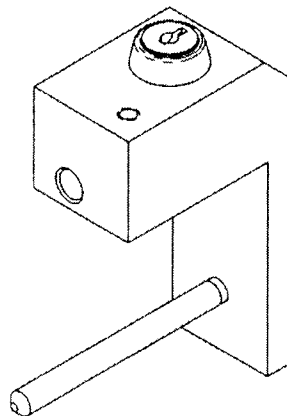
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 2 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

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[Signature]
05/04/23



SECTION A-A

D3372-053 LOCK ASS'Y

NOTES:

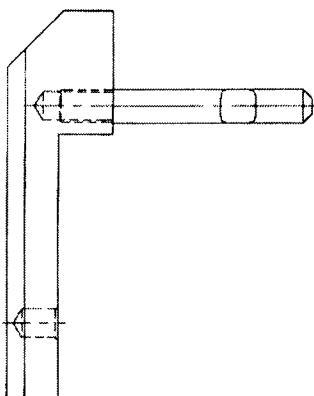
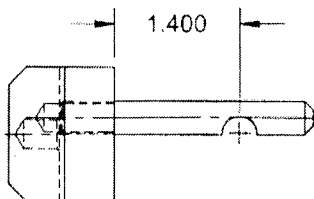
- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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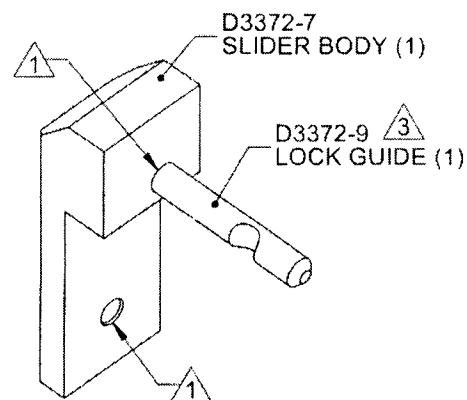
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DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:2



RELEASED
05/04/23



D3372-055 SLIDER ASS'Y

NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

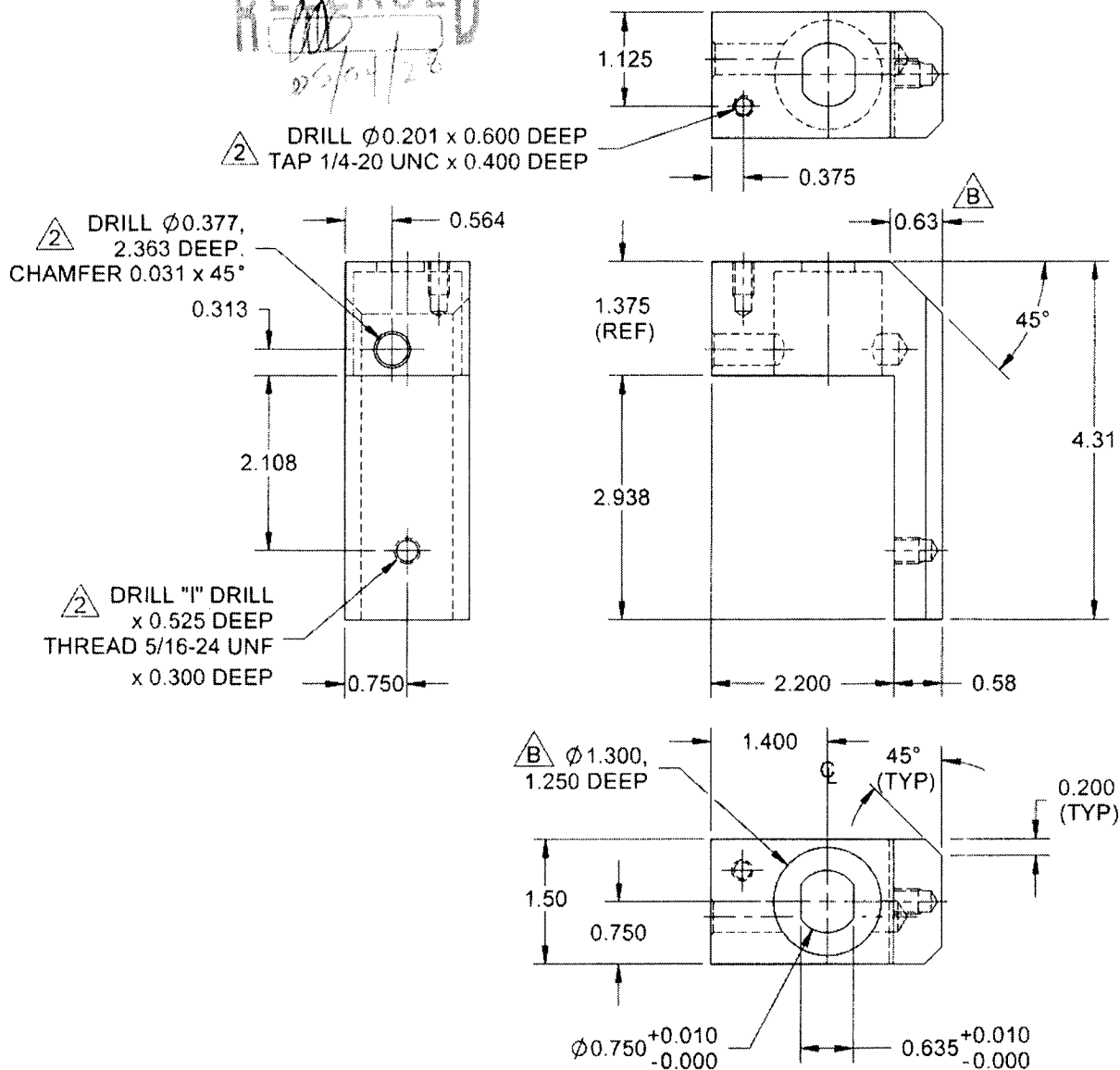
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

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[Signature]
25/04/23



D3372-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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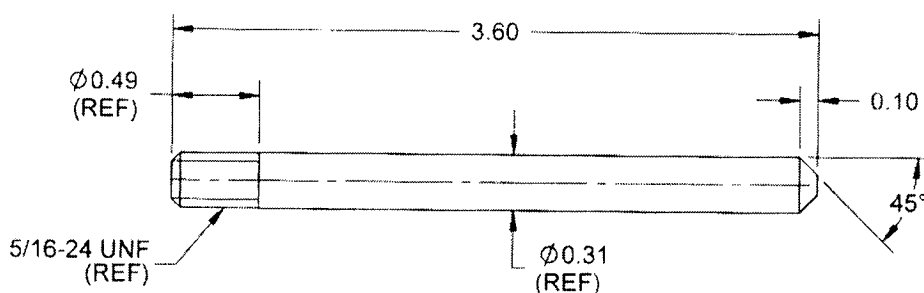
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

SPECIFICATION CONTROL DRAWING

RELEASED
[Signature]
05/04/23



D3372-3 GUIDE

NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

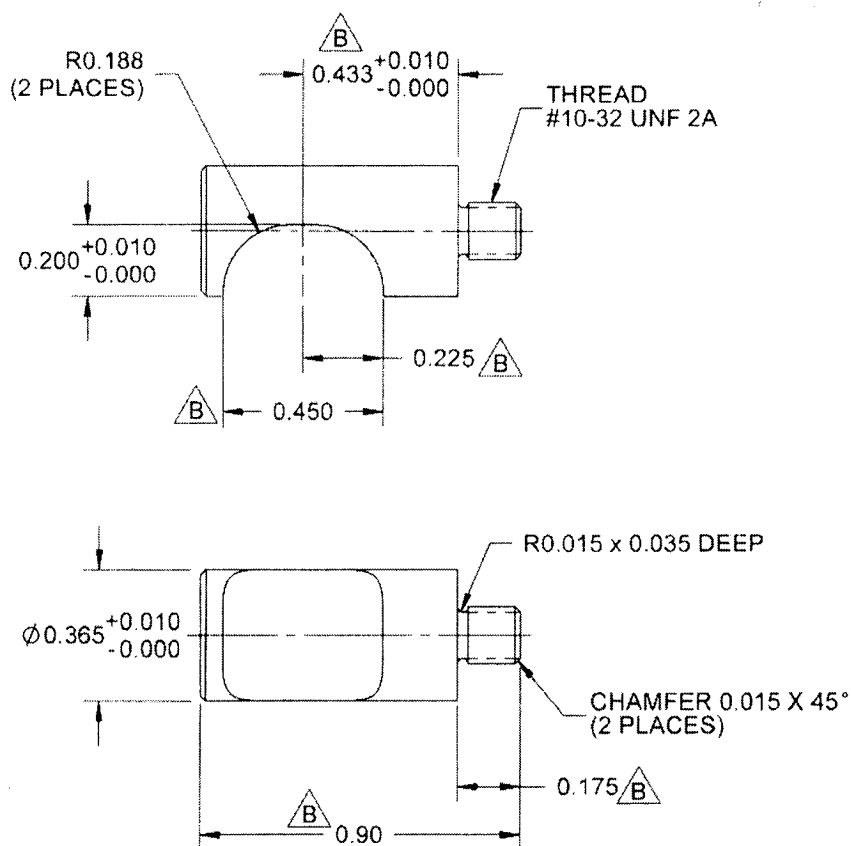
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

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[Signature]
05/04/23



D3372-5 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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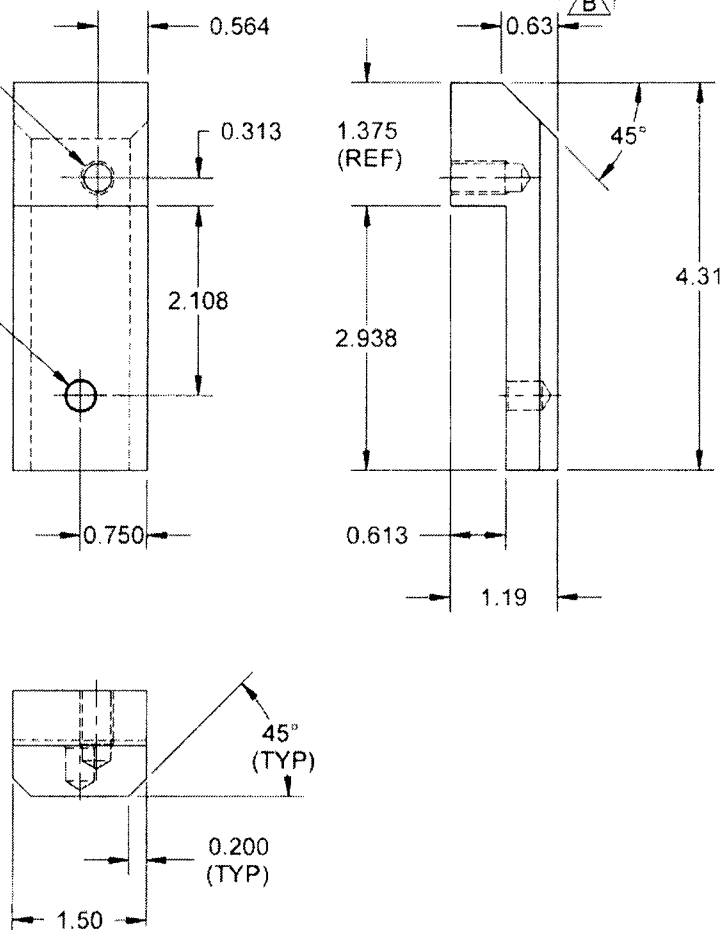
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

DRILL $\phi 0.332$
("Q" DRILL) x 0.881 DEEP,
THREAD 3/8-24 UNF x 0.600 DEEP

DRILL $\phi 0.323$
("P" DRILL) x 0.500 DEEP
CHAMFER 0.030 x 30°



D3372-7 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

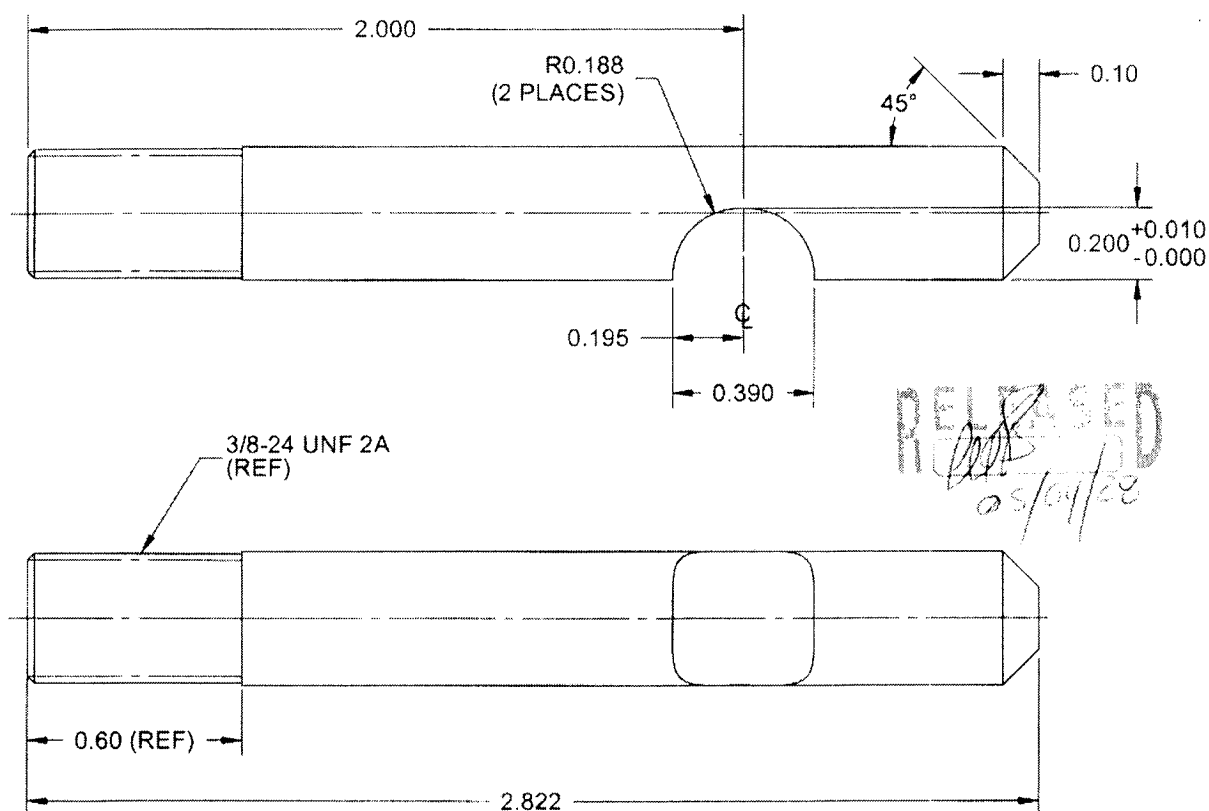
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



D3372-9 LOCK GUIDE

NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

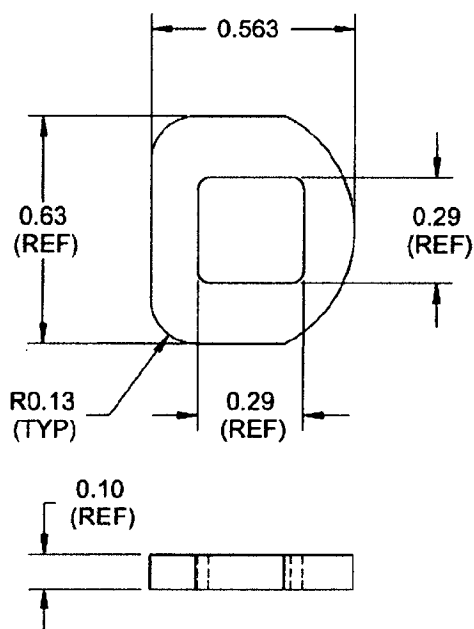
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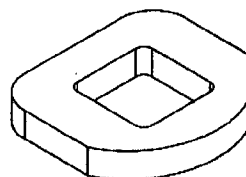
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DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



RELEASED
[Signature]

05/02/11



-5
D3369 SPACER



NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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